

Rush Need July 14th 12 test

Dart Aerospace Ltd.

Date: Tuesday, 04/07/2006 11:46:55 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FITTING
<b>Job Number</b> : 27758	
<b>Estimate Number</b> : 10869	
<b>P.O. Number</b> : NIA	<b>Part Number</b> : D32161
<b>This Issue</b> : 04/07/2006 <b>S.O. No.</b> : NIA	<b>Drawing Number</b> : D3216 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 28/06/2006 <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 25881	<b>Material</b> : NIA
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 12/07/2006
<b>Checked &amp; Approved By</b> : [Signature]	<b>Qty:</b> 50 <b>Um:</b> Each
<b>Comment</b> : Est: A 03.10.28 New Issue KJ/RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S11GA	304/316 .125 Sheet
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101463



**Comment:** Qty.: 0.0288 sf(s)/Unit Total : 1.4400 sf(s)  
304/316 .125 Sheet

MM 06 07 07

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

MM 06 07 07 (50)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

MM 06 07 07

(50)

4.0	QC2 B ac	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

06 07 07 (50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

Tumble until parts have a polished finish.

m.f. 06/07/11  
mf 06/07/12

(50)  
(50)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SB 06/07/12 50

Date: Tuesday, 04/07/2006 11:46:56 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 27758

Part Number: D32161

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57416

*Rec'd 7/15 SD*

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06.07.17*

Job Completion



*U 06-07-15*

Date: Wednesday, 6/28/2006 4:18:45 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 27758		
Estimate Number	: 10869		
P.O. Number	:	Part Number	: D32161
This Issue	: 6/28/2006 S.O. No. :	Drawing Number	: D3216 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 25881	Material	:
Written By	:	Due Date	: 7/12/2006
Checked & Approved By	: <i>06 06 29</i>	Qty:	50 Um: Each
Comment	: Est: A 03.10.28 New Issue KJ/RF		

*See  
 Repercent  
 w/o  
 attached.*

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O:

Email or Ship DXF file to vendor

Laser Cut D3216-1 Fitting as per Dwg D3216

Material release note is required.

*Material:  
 (M30450125)  
 (02883F)*

Batch:

*M6789  
 M101463*

*M 06 07 06*

2.0 D3216TF



*Water Jet  
 Proj Rev. A*

Fitting

*Proj Rev. A*



Comment: Qty: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Fitting

*M 06 07 01 (50)*

3.0	PACKAGING 1	QC2	PACKAGING RESOURCE #1
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*M 06 07 01*



Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

*M 06 07 01 (50)*

4.0	QC8	QC8	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

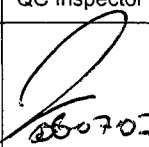
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary.

Tumble until parts have a polished finish.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-07	4.0	QC 8 for second check. Permanent change					 06-07-07	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/28/2006 4:18:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 27758

Part Number: D32161

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

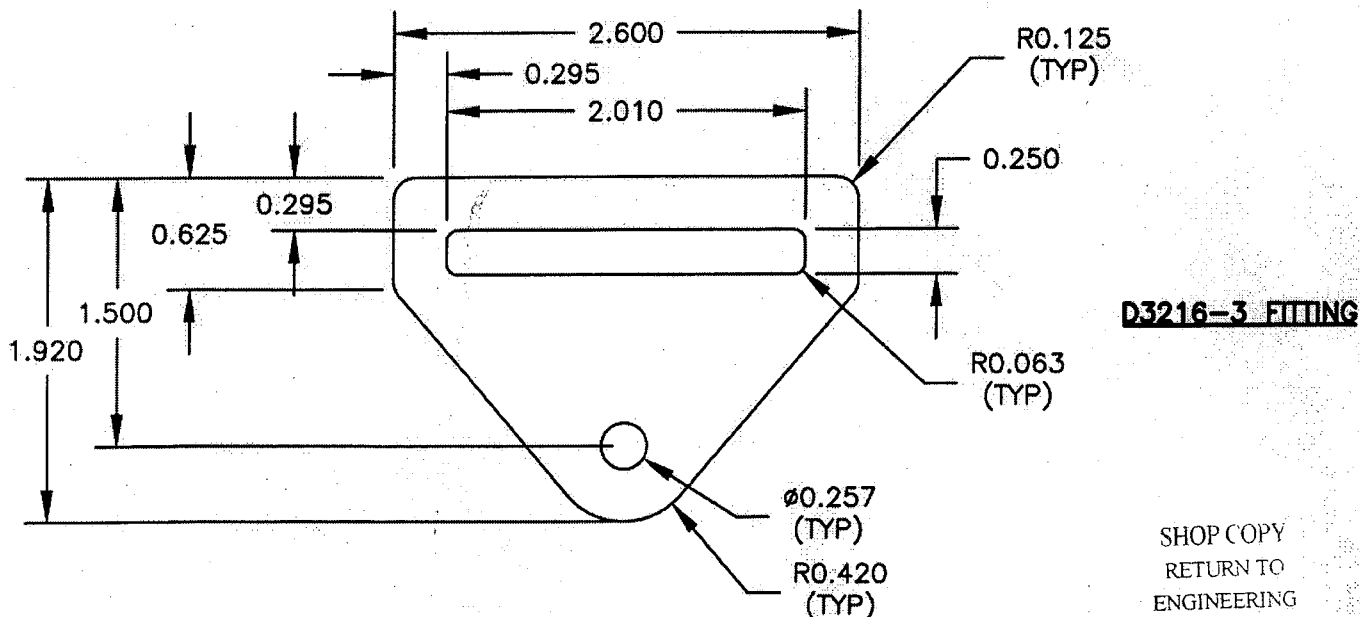
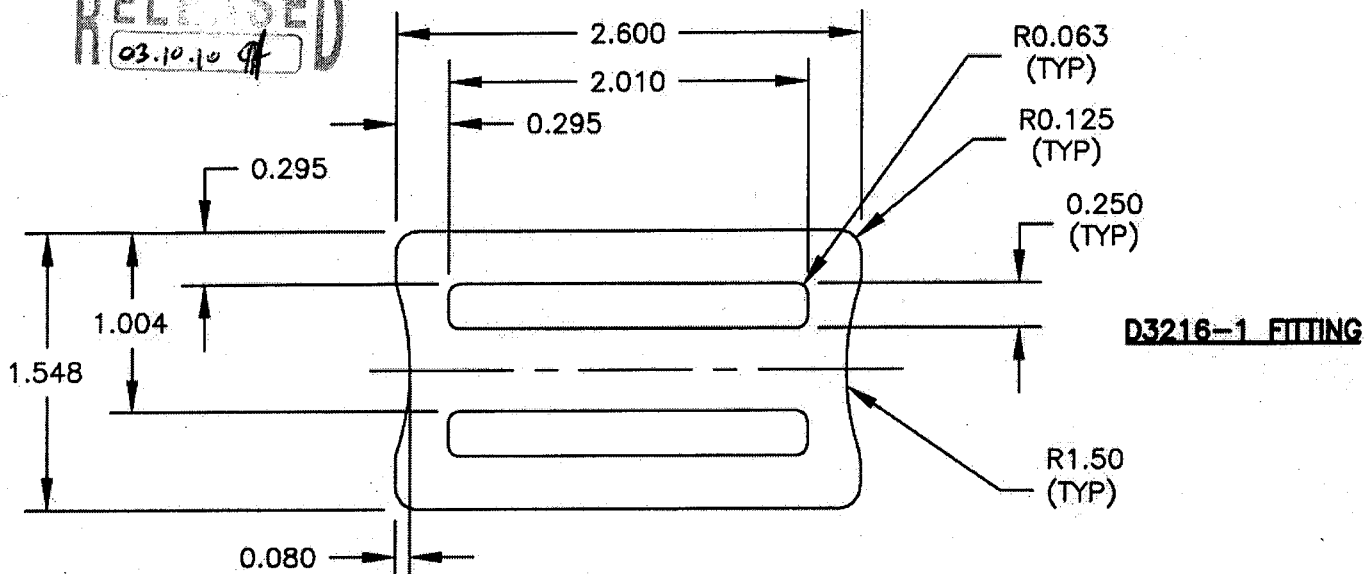
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>ap</i>	DRAWN BY <i>ap</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3216	REV. A SHEET 1 OF 1
DATE 03.09.26		TITLE FITTING	SCALE 1:1
A	03.09.26	NEW ISSUE	

RELEASED  
03.10.10 *qf*



**D3216-1/-3 FITTING**

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S110A)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27758

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DART AEROSPACE LTD		Work Order:	27758
Description:		Part Number:	3216-1
Inspection Dwg: , Rev:		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	X	Prototype
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[illegible]

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	—
Date:	06.07.07	Date:	06.07.07	Date:	—

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	